

Split

Dart Aerospace Ltd.

Date: Thursday, 5/31/2007 7:23:16 AM
User: Kim Johnston

Process Sheet

POSITIVE RECALL

EFFECTIVE 07/06/07 AUTH W

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32718-1
Estimate Number : 12576
P.O. Number : *N/A*
This Issue : 5/31/2007 S.O. No. : *N/A*
Prsht Rev. : NC
First Issue : *N/A* Type : LARGE FAB ASSY
Previous Run : 29411
Written By : *07.05.31*
Checked & Approved By : *07.05.31*
Comment : Est Rev:A New Issue 06-11-09 JLM

Drawing Name : STEP RELEASED *07/06/07* DATE _____
Part Number : D3562041
Drawing Number : D3562 UNDER REVIEW
Project Number : N/A
Drawing Revision : A
Material : *N/A*
Due Date : 6/11/2007
Qty: *4* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u><i>B31984</i></u>

Check Material for any Dents or Defects

LE. 07.06.07

2.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<u><i>B29340 = 1</i></u> <u><i>B30883 = 9</i></u>

LE. 07.06.07

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

LE a.m 07/06/07

(5)

2-Deburr and bevel ends for welding

LE 07.06.07

LE 07.06.07

3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod *M102756*

4-Grind end cap welds flush as per Dwg D3562

a.m 07.06.07

day, 5/31/2007 7:23:16 AM
Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32718

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

QC5

INSPECT WORK TO CURRENT STEP



QC5 2006-07 (5)



Comment: INSPECT WORK TO CURRENT STEP

QC9 07/06/07 (5)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562. USING DT 8956

INSPECT WORK TO CURRENT STEP

6.0

QC5



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 07-06-07

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/06/07 (5)

9.0

D3560041

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM WELDMENT

B 32643

FF 07-06-07

10.0

D3560043

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM WELDMENT

Batch: B 32646

FF 07-06-07

11.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total: 180.0000 Each(s)

Blind Rivet

batch: 2012092 34

SEE W/D CHANGE

FF 07-06-07

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32718

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet legs using Magnabond as per dwg D3562.
Ensure to wipe off any excess magnabond of the step



JE-07.06.13

4

A/R Magnabond 6398

Batch: *M103628*

JE 07.06.13

4

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Joe 14 (1)

Test Fitted on A/K.

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562 & QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod *M102756*

JE-07.06.14

4

2-Grind end cap welds flush as per Dwg D3562

JE a.m.

07.06.14

4

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

LH

07/06/15

(4)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Joe 14 (1)

LH

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR.

07.06.15

(4)

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: *M104281*

M-h

07/06/15

(4X)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32718

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



2

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

07-06-18

20.0

PACKAGING 1

PACKAGING RESOURCE #1



* SEE WID CHANGE FOR
STEP 19.5



Comment: PACKAGING RESOURCE #1
Pick Assembly Kit

PD 07-06-19

U 07-06-19

Job Completion



POSITIVE RECALL

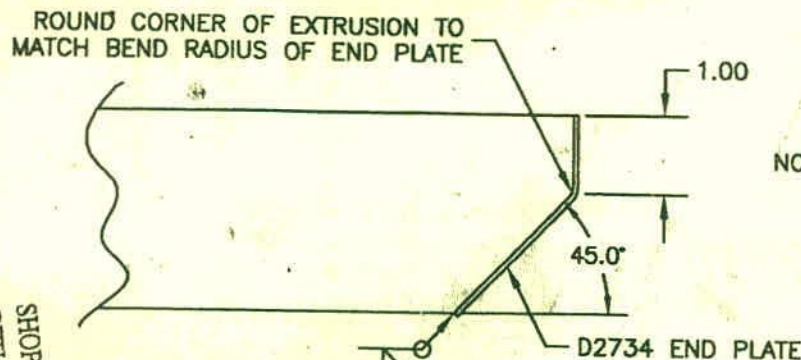
EFFECTIVE _____ AUTH _____

RELEASED U DATE 07-06-19

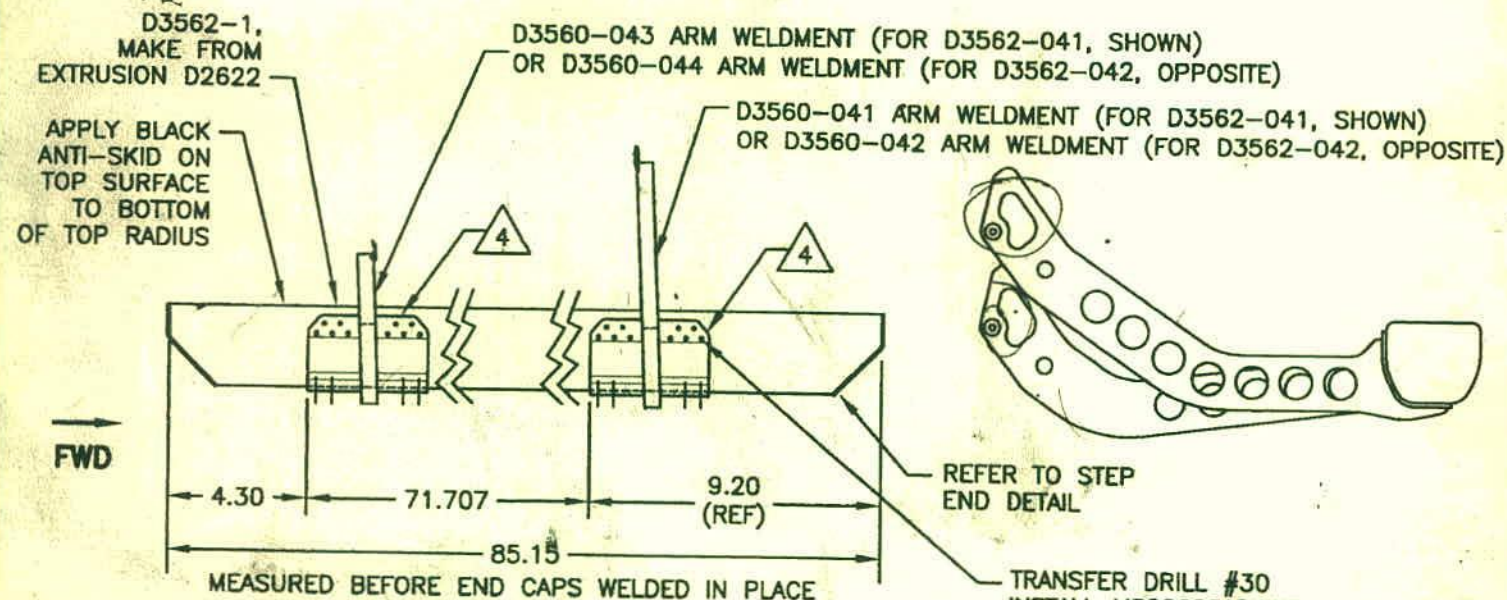


RELEASED
07.01.2007

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE



D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004
- 3) FINISH:

AFTER WELDING END PLATES AND PRIOR TO DRILLING/INSTALLING ARM WELDMENTS:

- i) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- ii) POWDER COAT GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) INSTALL ARM WELDMENTS WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS-B2 SEALANT BETWEEN THE ARM WELDMENT AND STEP EXTRUSION
- 5) ALL DIMENSIONS ARE IN INCHES

TRANSFER DRILL #30
INSTALL MS20600AD4W5
RIVET (36 PLACES),
DEBURR & TOUCH UP HOLES
WITH CHEMICAL CONVERSION
COAT BEFORE RIVETING,
TOUCH-UP RIVET HEADS
WITH PAINT PER
DART QSI 005 4.2

MAGNABOND

07.06.07

REF IS EMAIL

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CP	CP	D3562
DATE	TITLE	REV. B
07.01.15	STEP ASSEMBLY	SHEET 1 OF 1
A	NEW ISSUE	SCALE
06.09.26		NIS
B	ARMS NOW RIVETED TO STEP	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32718

